

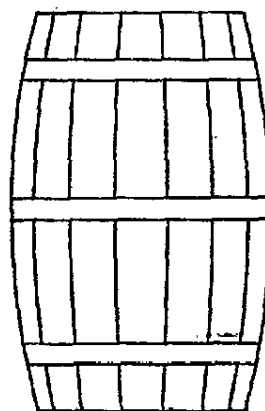
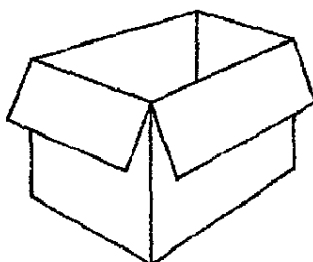
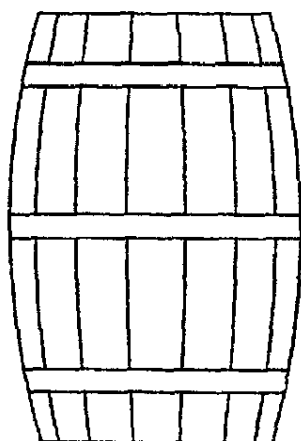
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Revised

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FINISHED PRODUCT SPECIFICATIONS AND DISPOSITIONING GUIDELINES



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TRADE SECRET-PRODUCED BY PHILIP MORRIS-SUBJECT TO
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REVISION DATE: 5/24/89

RLTC PRODUCT ANALYTICAL REJECTION & DISPOSITIONING LIMITS

PRODUCT PARAMETER	TARGET %	RANGE %	REJECTION CRITERIA	
			BEFORE ROTARY DISPOSITION	BROKE PULPER DISPOSITION
Solubles	46.5	44.5 - 48.5	43.5 - 44.4 48.6 - 49.5	< 43.5 > 49.5
PG	3.00	2.50 - 3.50	2.20 - 2.49 & 3.51 - 3.80	< 2.20 & > 3.80
Glycerine	2.50	2.0 - 3.0	1.75 - 1.99 & 3.01 - 3.25	< 1.75 & > 3.25
Potassium Sorbate	0.15	0.10 - 0.20	0.08 - 0.09 & 0.21 - 0.22	< .08 & > 0.22
Nitrate- Nitrogen (Domestic)		≤ 0.55	0.56 - 0.60	> .60
Nitrate- Nitrogen (Export)		≤ .50	-	> .50
Oven Volatiles Container Avg.	14.5	13.0 - 16.0	12.5 -12.9 & 16.1 -18.0	<12.5 & >18.0
Container Std. Dev.		< 2.0 Deviation	2.0 - 2.49	> 2.49
HHD 1-Min. Avg. Std. Dev. Case		<1.5 <1.2		≥ 1.5 ≥ 1.2
O.V. Cores	-	12.5 - 15.5	12.0 -12.4 15.6 -17.5	<12.0 >17.5
Cooked Flavor		> 1.00 < 5.00		B.P. If outside of range
Paraben	700 ppm	550 - 1100 ppm	-	>1100 or <550
*HHD Weights	900 ± 25 lbs.	875 - 925 lbs.	<875 lbs. >925 lbs.	N/A N/A
** Case Weights	161 ± 8 kg.	153 - 169 kg.	<153 kg. >169 kg.	N/A N/A

* RLTC or RLB Domestic Product

** RLTC or RLB Export Product

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RLB PRODUCT ANALYTICAL REJECTION & DISPOSITIONING LIMITS

PRODUCT PARAMETER	TARGET %	RANGE %	REJECTION CRITERIA	
			BEFORE ROTARY DISPOSITION	BROKE PULPER DISPOSITION
Solubles	47.5	45.5 - 49.5	44.5 - 45.4 49.6 - 50.5	< 44.5 > 50.5
PG	3.00	2.50 - 3.50	2.20 - 2.49 & 3.51 - 3.80	< 2.20 & > 3.80
Glycerine	2.50	2.50 - 3.50	1.75 - 1.99 & 3.01 - 3.25	< 1.75 & > 3.25
Urea	3.00	2.5 - 3.5	2.20 - 2.49 3.51 - 3.80	< 2.20 > 3.80
Potassium Sorbate	0.15	0.10 - 0.20	0.08 - 0.09 & 0.21 - 0.22	< .08 & > 0.22
Dap	2.25	1.75 - 2.75	1.50 - 1.75 2.76 - 3.00	< 1.50 > 3.00
Nitrate- Nitrogen (Domestic)		≤ 0.55	0.56 - 0.60	> .60
Nitrate- Nitrogen (Export)		≤ .50	-	> .50
Oven Volatiles				
Container Avg.	14.5	13.0 - 16.0	12.5 -12.9 & 16.1 -18.0	<12.5 & >18.0
Container Std. Dev.		< 2.0 Deviation	2.0 - 2.49	> 2.49
HHD 1-Min. Avg. Std. Dev. Case		<1.5 <1.2		≥ 1.5 ≥ 1.2
O.V. Cores	-	12.5 - 15.5	12.0 -12.4 15.6 -17.5	<12.0 >17.5
Cochise	1.00	0.75 - 1.25		< .75 or >1.25
Jono	0.20	0.15 - 0.25		< .15 or > .25
Isosweet	2.00	1.50 - 2.50		<1.50 or >2.50
Paraben	700 ppm	550 - 1100 ppm	-	<550 >1100

LOW HUMECTANT (RLTCG & RLBG)

PG	2.50	2.00 - 3.00	1.75 - 1.99 3.01 - 3.25	<1.75 >3.25
GLY	2.00	1.50 - 2.50	1.30 - 1.49 2.51 - 2.70	<1.30 >2.70
Total Humectant		≤ 5.00		
Oven Volatiles	14.0	12.5 -15.5	12.0 -12.4 15.6 -17.5	<12.0 >17.5
Nitrate Nitrogen	-	< .50		>.50

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PRODUCT REJECTED BY PRODUCTION

<u>CATEGORY</u>	<u>TERM</u>	<u>DEFINITION</u>	<u>DISPOSITION</u>
Packaging & Handling	Damaged	HHD or Case that is damaged during packing or handling & cannot be repaired.	BH
	Underweight	HHD packed out with net wt. of 874 pounds or less.	BH
		Cases packed out with net wt. of 153 kg or less (339 pounds)	BH
	Overweight	HHD packed out with net wt. of 926 pounds or more	BH
		Cases packed out with net wt. of 169 kg or more (371 pounds)	
	Depressed Lid	Any HHD with lid depressed 2 1/2" below top edge of mat at any point.	Pads picked out & Disp. BP
Poor Distribution	Skewed	Any HHD with <1 1/2" or more lean off vertical, measured by level & rule.	Pads picked out & Disp. BP
	Pad Check	Any container rejected for suspected padding.	Pads picked out & Disp. BP
	Distributor Problems	Any container rejected for poor distribution, distributor stopped, etc.	Pads picked out & Disp. BP
Finish Sheet Appearance	Irregular Cut	Big pieces, paper dolls, small pieces, etc.	BP
	Rough Sheet	Any container rejected for rough sheet, i.e., always rough on bottom	BP
	Size Spots	Any container rejected for size spots, thick size on edges, or any other sizing irregularities	BP
	Streaks	Any container rejected for streaks in finished product due to sheet formation	BP
	Off Color	Any container that is rejected due to color of finished product	BP

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<u>CATEGORY</u>	<u>TERM</u>	<u>DEFINITION</u>	<u>DISPOSITION</u>
Product Contamination	Oil on Container	Any container rejected for oil observed on container	Trash
	Dust	Containers rejected for suspected dust in product due to blowdown, etc.	BP
	Foreign Objects	Any container rejected for any object other than finished product i.e., dist plates, pens, safety glasses, gloves, etc.	Trash
	Fire Damage	Any container rejected due to tunnel dryer fire.	Trash
Felt Wash	Felt Wash	Underweight container removed from line packer when machine goes down for felt wash.	BH
Start-Up	Start-Up	Container with product run on any start-up, i.e., after blade change, felt wash, or any other down time, prior to switching to on-line packer	BP
Miscellaneous	Misc.	Container rejected for any reason not defined in above categories	*

* Determined by Management on an individual basis.

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